

6061 T6 R 0.375" x .058" w

Work Order ID **78019*****78019***

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December-28-11 1:28:50 PM

Item ID: D2649

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cross Bolt Spacer

Start Date: 23/12/2011 Start Qty: 400.00

400

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 11/12/28 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2649

Rev B1

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA214 on cobra machine.

400 0 12/01/03

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

400 0 12/01/03

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

JL 12-01-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78019

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78019

Page 2

Item ID: D2649 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cross Bolt Spacer
 Start Date: 23/12/2011 Start Qty: 400.00 ***400*** Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 400.00 ***400*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* Skidtubes	Memo 1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.	0.00				400	0	BE 12-01-26	
130 *130* Packaging	Identify as per dwg & Stock Location <u>LG</u>	0.00				400	0	BE 12-01-26	
Packaging	Memo ***STOCK IN SKIDTUBE CELL***	0.00							
140 *140* QC	QC21- Final Inspection - Work Order Release	0.00						12/1/26	
Quality Control	Memo	0.00							

12-01-26
400

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 78019

78019

Parent Item: D2649

D2649

Parent Item Name: Cross Bolt Spacer

Start Date: 23/12/2011

Required Date: 01/02/2012

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP F02.03.26Added turning on CobraNG
added cleaning DD verified :EC IPP Rev:G 10.05.11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased		No		100	f	808.1300	0.2833	119.2842			
M6061T6T0.375W.058									**	114.750'		12/01/03	
6061-T6 RD Tube .375 x.058W													

Location

Loc Qty

Loc Code

MAT014

808.13

116920

0.578

119087

13.685

119376

492

119644

1.867

119678

300

108.000'
+ 750'
6.000'

W/O:		WORK ORDER CHANGES					
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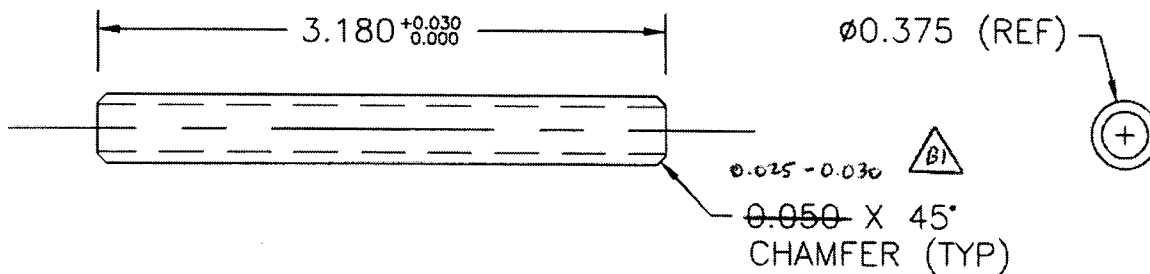
NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	# <i>CP</i> 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS

SYN BY
R TO
ENG ENG
(CONT) ED COPY
SUBJECT ENDMENT
WITH TICE
WORK ORDER
NO. 78019 M.L.J
1112128



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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